



SHORE D POLYURETHANES

"Dedicated to QUALITY, SERVICE, SAFETY, and INNOVATION"

TC-865 A/B 65 SHORE D URETHANE CASTING SYSTEM

PRODUCT DESCRIPTION:

TC-865 A/B is a medium viscosity, economical and easy to handle two component urethane compound. This system cures relatively fast at room temperature producing tough, impact resistant castings. TC-865 A/B is recommended in applications where a resilient surface hardness is desired while maintaining good flexibility.

PHYSICAL PROPERTIES:

Hardness, Shore D ASTM D-2240	65 ± 2
Specific Gravity, (g/cc) cured ASTM-792	1.15
Cubic Inches Per Pound.....	24
Tensile Strength, (psi) ASTM D-638.....	2,475
Tensile Modulus, (psi) ASTM D-638	99,000
Elongation, (%) ASTM D-638.....	70
Flexural Strength, (psi) ASTM D-790	2,875
Flexural Modulus, (psi) ASTM D-790.....	92,850
Tear Strength, (pli) ASTM D-624.....	585
Izod Impact, (ft.-lb./in.) ASTM D-256.....	0.85
Shrinkage, (in./in.) linear (12" X ½" X ½").....	0.005

HANDLING PROPERTIES:

Mix Ratio (by weight):	
Part A	100 parts by weight
Part B	100 parts by weight
Mix Ratio (by volume):	
Part A	100 parts by volume
Part B	95 parts by volume
Viscosity, (cps) @ 77°F (25°C) Brookfield:	
Part A	1,350
Part B	1,500
Mixed.....	1,400
Color:	
Part A	Clear, light yellow
Part B	Cream
Work Time, (100-gram mass) @ 77°F (25°C)	10 minutes
Demold Time @ 77°F (25°C).....	3 hour minimum, ½" thick sections 2 hours or less in mass cast
Cure Schedule.....	3 days